Work Orde Friday, October				*125	<u> </u>	<b>f</b>						Page 1
Revision ID:	D3536-25 Gasket Cente			Accept	*N90	<b>10040</b>	110	<b>)</b> *	Setup S	74	έΝΙ.	S1* S2*
Start Date: Required Date:	10/27/14	Start Qty: 50.00 Req'd Qty: 50.00			Cust It	tem ID: ner:				•	1113	<b>〜</b>
Reference: Approvals:	Process Pl	an:	Date: 14/10/24	Tooling: SPC (Y/N):		Date:		·		Stop _		R1*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool	ID Tool#	Plan Code	Accept Qty	Rejec Qty	t Reje		Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3536	Re	v A										
*100 *100* Waterjet FLOW CNC Waterje	et ·	FLOW WATER JET  Memo 1-Cut as p Deburr if r		0.00 0.00 v:A Prog Rev:A	2-			<u>(51)</u>			· pi	14/11/0
110 *110* QC Quality Control		QC2- Inspect parts off  Memo	machine FAI/FAIB	0.00				(51)	. <u></u>	a/	pe.	14/11/12
<sup>120</sup> *1 <i>2</i> ∩*		QC8- Inspect parts - se	cond check	0.00				5/				DAS <b>38</b> 9-89
QC		Memo	•	0.00				-				

Quality Control

NOV 1 7 2014

DQA:	QA: Date:												TOACT
					<b>WORK ORDER NON</b>	-C(	ONFO	RMANCE / UPI	DATE				AEROSPACE
QA Closed:		Date:					÷		W	ork Order up	date only		•
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIG	-1.			<del></del>	Rework	1		Skid-tube	Crosstube	1	Water Jet		ngineering
Part N	Jo				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	┤ `	Quality
rarer			<u> </u>		Use-as-is			noforming	Finishing	4	e/Packaging		Other
NCR N	No			<del></del>	Suspected Unapproved			-	Composite		Supplier		
Root				Desci	ription of work order update		Initial	Actio	n	Sign &		T-	
Cause	Date	Step	Qty		or non-conformance	)	nief Eng	1		Date	Verification	1	QC Inspector
Design		<u> </u>											
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material					!								
Operator													
Offset/Setup						1							
Process													
Supplier												ŀ	
Training					÷								
Transport			,										
Unapproved													
						FA	ULT CAT	TEGORY					
Landi	ng Gear				General		•			-	-		
	Bendin	3			Bend		Folio/P	Program		Outside Dim	ensions	Pre	ssure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set	t-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	t [	Ter	nperature/Cure
	Crimp/I	Kink/Ripple	e/Wave		Burrs		Inspecti	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	We	ld
	Cuffs				Contamination		Instruct	tions Incomplete/Un	clear	Part Moved		Wr	ong Stock Pulled
	Crushin	g			Countersink		1	gned/off center		Positioned W			
	Heat Tr	eat			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Oth	ner
	Inspect	ion Strip in	Tube	Ŀ	Drawing		Misread	d			<u>.</u>		
	Marks/	Chatter			Drill Holes		Off-set						
	Turning	Sequence	!		Finish		Out of 0	Calibration					
	Wave/	wist in Tul	be		Fit/Function		Out of S	Sequence					

Work Orde Friday, October				*12!	5909*							Page
Item ID: Revision ID: Item Name:	D3536-25 Gasket Cente	ा		Accept	*N900	040	10	<b>n</b> *	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	10/27/14 11/28/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item Customer:	ID:				C4 4		
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate: ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130*	)	Operation Description Identify as per dwg & Sto	ock Location: 1-12-06	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

0.00

\*140\*

Packaging

Packaging

Quality Control

Memo

Memo

0.00

Page 2

DQA:		Date	:										7
0.4.611		Data	_		WORK ORDER NON	-C(	ONFO	RMANCE / U		/		AEROSP	4 C E
QA Closed:		Date	:			1	1		V	/ork Order up	date only		
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
					Rework	]		Skid-tube	Crosstube		Water Jet	Engineering	$\neg$
Part N	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1	1	noforming	Finishing	<b>⊣</b>	re/Packaging	Other	
NCR N	0.				Suspected Unapproved	1		Large Fab	Composite	1	Supplier	┦	
			•	_	,	•							
Root				Desc	ription of work order update		Initial	Ac	tion	Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspecto	or
Design									•				
Doc/Data											•		
Equip/Tooling	<u>.</u>												
Handling/Pre	_												
Material				ł									
Operator													
Offset/Setup	_												
Process	_			Ì									
Supplier													
Training	_												
Transport													
Unapproved				<u> </u>		<u> </u>							
						FAI	ULT CAT	TEGORY					
Landin F	g Gear			<del> </del>	General		1 (_		<u></u>	٦		<del>_</del>	
-	Bendir	-		-	Bend	_	1	rogram	_	Outside Dim	⊢	Pressure/Forced	
-	<del> </del>	Not Conce	entric	-	BOM/Route	_	Grain		-	Over/Under	<u> </u>	Set-up	
}	Cracks		<b>(</b> ) <b>4</b> .		Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	<b>}-</b> -	Temperature/Cu	re
}	<del></del>   '	/Kink/Rippl	e/Wave		Burrs	_	1	on Incomplete/U	· · · · · · · · · · · · · · · · · · ·	Part Lost/Mi	ssing	Weld	
}	Cuffs			<u> </u>	Contamination	<u> </u>	ł	ions Incomplete/	Unclear	Part Moved	<u>.</u> L	Wrong Stock Pull	ed
<u> </u>	Crushi	_		-	Countersink	-	1	ned/off center	<u> </u>	Positioned W	_		
}	Heat T		. Tl	<u> </u>	Cut Too Short		Mislabe		L	Power Loss/S	ourge	Other	
	_	tion Strip ir	ı ıupe	-	Drawing	<u> </u>	Misread	1				·	·····
		/Chatter		-	Drill Holes		Off-set	Talibuaki a					
		g Sequence			Finish	_	1	Calibration			<u> </u>		
	[wave/	Twist in Tu	ne		Fit/Function		Out of S	Sequence					

## **Picklist Print**

Friday, October 24, 2014 11:13:37 AM

Work Order ID: 125909

\*125909\*

Parent Item:

D3536-25

\*D3536-25\*

Parent Item Name: Gasket Center

**Start Date:** 10/27/14

Required Date: 11/28/14

**Start Qty: 50.00** 

Required Qty: 50.00

**Comments:** 

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No		reset 14.5	100	sf	171.9341	0.5956 <b>(</b>	34			, /
*MNFO60	S 063*								**			De 18	111/12

**NEOPRENE SHEET 0.063** 

<b>Location</b>	Loc Qty	Loc Code	
MAT052	171.9341		
M126546	2.3		*****
M128339	169.6341		
1 ma .ma .			

130840

DQA:		_ Date:										TAM.P.	r
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UI		Vork Order uj	ndate only - [	AEROSPAC	E •
Q/10364.							<u> </u>				· ·		
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
		<del></del>			Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	lo			<del></del>	Suspected Unapproved	]		Large Fab	Composite		Supplier		
Root				Desci	ription of work order update		I Initial	Acti	ion	Sign &			_
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector	
Design		1.											
Doc/Data		1											
Equip/Tooling													
Handling/Pre													
Material		ļ											
Operator													
Offset/Setup						ļ ·							
Process													
Supplier						ŀ							
Training											•		
Transport													
Unapproved			<u> </u>										
					· · · · · · · · · · · · · · · · · · ·	FA	ULT CAT	EGORY			<u> </u>		
Landir F	ng Gear				General		1			<b>–</b>	Г	· ·	
}	Bending			<u> </u>	Bend		ł .	rogram	<u> </u> -	Outside Dim		Pressure/Forced	
}	<b></b> i	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain		<u> </u>	Over/Under	<del> </del>	Set-up	
}	Cracks			-	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	<b>├</b>	Temperature/Cure	
}		nk/Ripple	/Wave		Burrs		1	on Incomplete/Un	· -	Part Lost/Mi	ssing	Weld	
}	Cuffs			$\vdash$	Contamination	<u> </u>	1	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled	
}	Crushing			-	Countersink			ned/off center	<u> </u>	Positioned V		7	
}	Heat Tre		T la =		Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	Surge	Other	$\dashv$
}		on Strip in	eauı		Drawing Drill Holos	$\vdash$	Misread						ᅴ
}	Marks/C			-	Drill Holes	$\vdash$	Off-set	Salitanaki a c					$\dashv$
	<b>—</b> i	Sequence			Finish	$\vdash$	l	Calibration					_
į	vvave/TV	vist in Tub	ie.		Fit/Function	1 1	Out of S	equence					

DART AEROSPACE LTD	Work Order:	125909
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	-		Tape	
16.35	+/-0.030	16.35	-			
10.90	+/-0.030	10.90	_			
5.45	+/-0.030	5.45	_			
6.00	+/-0.030	6.00	_	-		
6.75	+/-0.030	6 75	_	-		
12.75	+/-0.030	12.75	_			
1.89	+/-0.030	1.49	_	,		-
0.30	+/-0.030	.30				
0.30	+/-0.030	,30	1			
Ø0.19	+0.005/-0.001	×. 189	7			
			AS			

				38		
Measured by:	1/	D-,	Audited by:	9-89	Prototype Approval:	N/A
Date:	14/	11/12	Date:	NOV 1 7 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	R

26.65 23.15 21.15 17.65 13.40 - 0.90 **-** 5.65 1.89 DETAIL A 8.00 3.90 Ø0.19 (TYP 3 PLS) 14.00 **D3536-11 GASKET** 





CHECKED

£

DRAWING NO.

SHEET

1 OF 6 REV.

SCALE

B

DART

AEROSPACE (

USA,

NC.

90

0 25

GASKET

➣

06.10.25

NEW ISSUE

32.90	
29.40	
27.40	
23.90	
18.98	
14.07	
9.15	0.90
5.65	
	1
Q	- 1.89
DETAIL A -/ 3.90	· ·
60.19	
(TYP 4 PLS) - 20.00	

D3536-13 GASKET

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

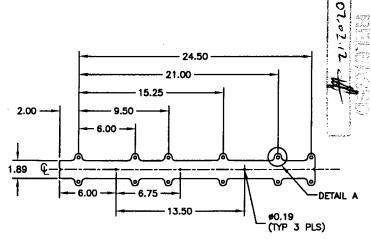
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

Į, DOCUMENT - 52.85 07:02:12 48.20 ï 44.70 Copyright @ 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 33.92 28.53 -- 23.14 -- 17.75 -DETAIL A · 4.75 <del>-</del> 2.00 1.89 6.00 06.10. CHECKED 0.90 -16.00 ø0.19 (TYP 6 PLS) - 24.00 32.00 25 B B 48.00 D3536-23 GASKET DRAWING NO. GASKET 刑匠 DART 1.45 16.35 DETAIL A AEROSPACE PORT HADLOCK, 10.90 RO.06 (TYP) 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE 1.89 3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI D18 UNLESS OTHERWISE NOTED R0.25 TOOLING NOTCH (TYP) 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT **Ø**0.19 PERMANENT INK MARKER PURPOSE (TYP 3 PLS) 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-25 GASKET SHEET 3 욹 <u>ਵ</u> COPIED 유 1:10

22.50 19.00 14.25 2.00 ---9.50 - 6.00 --1.89 DETAIL A - 6.00 -(TYP 3 PLS) D3536-31 GASKET



D3536-33 GASKET

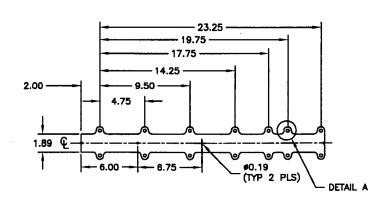
<b>Ľ</b> 0	TP3							
1)	MATERIAL	: BLACK						
		DURON	METER	(REF	DART	SPEC.	M-NEO6	30-S.063)
2)	FINISH:	NONE						

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET



CB CB	DRAWN BY	DART AEROSPACE USA, INC.	INC.
CHECKED	APPROVED /	DRAWING NO.	REV. A
84		D3536 SH	SHEET 4 OF 6
DATE		J. J	SCALE
06.10.25		GASKET	1:10

봀 DOCUMENT 30.75 ភ 27.25 Copyright @ 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 22.50 2.00 4.75 Œ 1.89 6.00 16.00 DETAIL A 21.00 **¢**0.19 06.10.25 (TYP 4 PLS) D3536-37 GASKET B 35.71 32.78 - 29.28 -DRAWING NO. - 25.78 -GASKET **IIII** 23.25 DART 19.75 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063) 2) FINISH: NONE 3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2.00 -AEROSPACE PORT HADLOCK, 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 1.88 7) SEE PAGE 6 FOR DETAILS AND SECTION ø0.19 (TYP 3 PLS) -- 5.00 · DETAIL A 9.00 28.00 -D3536-39 GASKET SHEET 유 **₹** COPIED S SCALE 읶 1:10

HS DOCUMENT ℧ Copyright @ 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 욹 COPIED

27.98 25.08 18.50 -15.00 12.47 - 8.97 -2.00 3.43 1.88 4.00 #0.19 (TYP 2 PLS) 3.90 DETAIL A

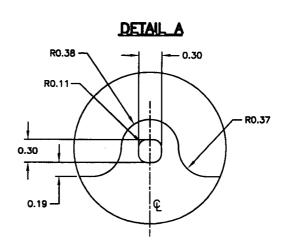
D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT ©
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER





ol



CB	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED ///	DRAWING NO. REV. A
PA	#	D3536 SHEET 6 OF 6
MIE.		TITLE SCALE
06.10.25		GASKET 1:10